

Date: Friday, 02/05/2008 11:56:02 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN DOOR ROLLER KIT, RH		
Job Number	: 39007			Part Number	: D412698012		
Estimate Number	: 10289			Drawing Number	: IIN D412-698 REVD		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/05/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: 02/05/2008 Type : MACHINED PARTS			Due Date	: 20/05/2008 Qty: 4 Um: Each		
Previous Run	: 38980						
Written By	:						
Checked & Approved By	: <u>JUL 08.5.02</u>						
Comment	: Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS						
	Est Rev:D 08-01-28 change to rev D ECN 1104 DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			<i>08/05/27 08.5.06</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-698-012 CHG003	
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
			<i>39013</i>
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D3121141	Bracket Assembly	
			<i>B37610 1X</i>
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)	
		Pick: Packing Kit	
		Qty Part Number Description Batch	
	3 D3121-141	Bracket Assembly	<i>B37610 1X</i>
4.0	D3121144	Bracket Assembly	
			<i>B39015 2X</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Packing Kit	
		Qty Part Number Description Batch	
	1 D3121-144	Bracket Assembly	<i>B39015 2X</i>
5.0	D3137043	Bracket Assembly	
			<i>B39720</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: Packing Kit	
		Qty Part Number Description Batch	
			<i>P 05/27 (4)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 11:56:02 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 39007

Part Number: D412698012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	D3137-043	Bracket Assembly
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6.0	D3183044	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3183-044	Bracket Assembly	<i>B38444</i>

7.0	D31991	Bracket
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
9 D3199-1	Bracket	<i>39016</i>

8.0	D32021	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3202-1	Cover	<i>38490</i>

9.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location: *Rej B*

*Rej B (4)*

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*MF 08-05-27*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
	X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
	X						D412-698-013	DOOR HANDLE KIT
	X						D412-698-015	DOOR SUPPORT KIT
	X						D412-698-017	REPLACEMENT DOOR TRACK KIT
		X					D412-698-019	BEARING OVERHAUL KIT
			X				D412-698-021	REPLACEMENT SHIM KIT
				7			D3121-21	BOLT
				5			D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
				1			D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
				2			D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1				1		D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
				3			D3238-1	SHIM
				1			D3238-3	SHIM
				2			D3238-5	SHIM
				6			D3238-11	SHIM
				2			D3238-13	SHIM
				4			D3238-15	SHIM
			12				AN960JD10L	WASHER
	8						AN960JD416L	WASHER
		12					MS21042L3	NUT (OR MS21042-3)
	8						MS21042L4	NUT (OR MS21042-4)
	16						MS24694-S98	SCREW
				1			MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 39007

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